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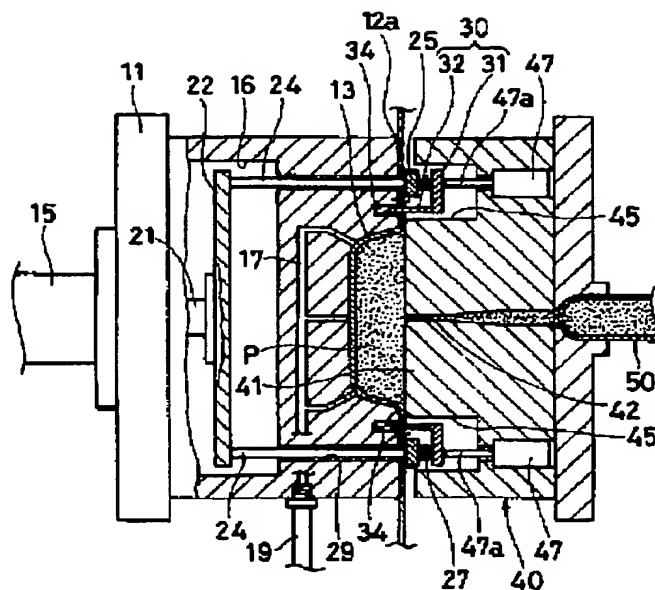
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TITLE : METHOD AND APPARATUS FOR
INJECTION MOLDING WITH
SIMULTANEOUS IN-MOLD
DECORATING



ABSTRACT : PROBLEM TO BE SOLVED: To make an installation and a space for sheet trimming unnecessary out of a mold and to bringing a decoration sheet into close contact with a cavity face by performing trimming process of the decoration sheet by a cutting means provided on a part except mold forming parts of a male mold and a female mold after drawing process and before taking-out process.

SOLUTION: A decoration sheet is sucked by vacuum and is drawn so as to be along the cavity face 13 of a female mold and mold clamping is performed. Then, a molten resin P is fed and filled into a cavity 13 from an injection molding machine through a path 42 for a melt to perform injection molding. Just before this injection molding is completed, four fluid pressure cylinders 47 arranged on a male mold 40 are actuated and cutting blades 30 are pushed on the parting face 12a side to perform a trimming process for cutting and separating a part to be stuck on an injection molding in the decoration sheet from other parts. Just after this cutting, the four fluid pressure cylinders 47 are made to OFF condition and the cutting blades 30 are returned to its original state and a molded article on which the decoration sheet is integrated by adhesion is taken out from the cavity 13.

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